

Date: Thursday, 11/9/2006 4:39:11 PM
User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	STA 155 BRACKET
Job Number	: 29410		
Estimate Number	: 11040		
P.O. Number	: N/A	Part Number	: D28042
This Issue	: 11/9/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2804 REV C
First Issue	: N/A	Project Number	: N/A
Previous Run	: 29182	Drawing Revision	: C
Written By		Material	: N/A
Checked & Approved By		Due Date	: 11/24/2006
Comment	: Est. A00.11.06 New Issue EC Est. B06.05.30 Blanks on wtjetEC Est Rev:C As per Rev C 06-11-09 JLM	Qty:	10 Um: Each
Additional Product			
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0500X12000	6061-T6 Bar .50" x 12.0"	
Comment:	Qty.: 0.7875 f(s)/Unit Total: 7.8750 f(s) 6061-T6 Bar .50" x 12.0" Material: 6061-T6 bar 12.00" x 0.50"	Batch: M102508	M 06/11/14 (10)
2.0	WATER JET	FLOW WATER JET	
Comment:	FLOW WATER JET 1-Cut as per Template DT8534 Dwg Rev: Q Prog Rev: C	J.F. 06/11/14	(10)
2.0	WATER JET	FLOW WATER JET	
Comment:	FLOW WATER JET 1-Cut as per Template DT8534 Dwg Rev: Q Prog Rev: C	J.F. 06/11/14	(10)
3.0	HAAS	HAAS CNC VERTICAL MACHINING #1	
Comment:	HAAS CNC VERTICAL MACHINING #1 Machine as per folio FA103	J.F. 06/11/15	(10)
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment:	INSPECT PARTS AS THEY COME OFF MACHINE	J.F. 06/11/15	(10)
5.0	QC8	SECOND CHECK	
Comment:	SECOND CHECK	S.A. 06/11/15	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 8/11/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STA 155 BRACKET

Job Number: 29410

Part Number: D28042

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble & Deburr

3.L 06/11/16

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ES [REDACTED] 06/11/16

8.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

YL FC 06/11/16 X10

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST156

06/11/17 (10)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/11/17 (10)

Job Completion



u 06/11/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/11/17	8.1	Qc3 inspect chemical conversion (permanent change)	EK MC	06/11/17			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	
Description: STA 155 Bracket	Part Number:	D2804-2
Inspection Dwg: D2804 Rev: B C <i>10/11/10</i>		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

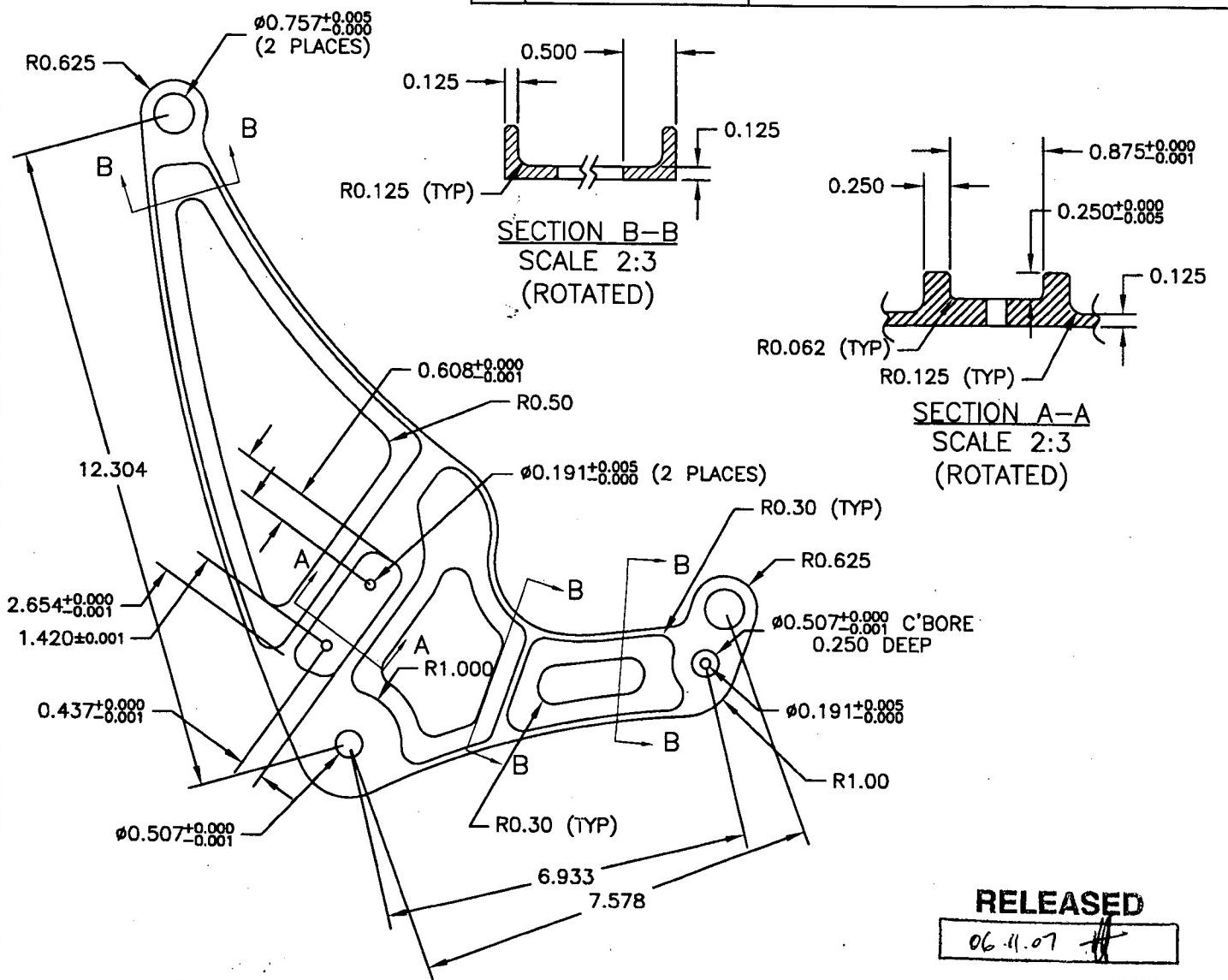
X First Article Prototype

Measured by: <u>J.F.</u>	Audited by: <u>SD</u>	Prototype Approval:	N/A
Date: <u>06/11/14</u>	Date: <u>06-11-14</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.12.10	New Issue	KJ/JLM	
B	05.04.25	Added 0.500 dimension	KJ/JLM	

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED 	APPROVED 	DRAWING NO. D2804	REV. C SHEET 1 OF 2	
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3	
A	00.11.07	NEW ISSUE		
B	04.11.22	ADD CUTOUTS & -043/-044		
C	06.10.16	CHANGE GEOM. TO ADD CLEARANCE		



D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)

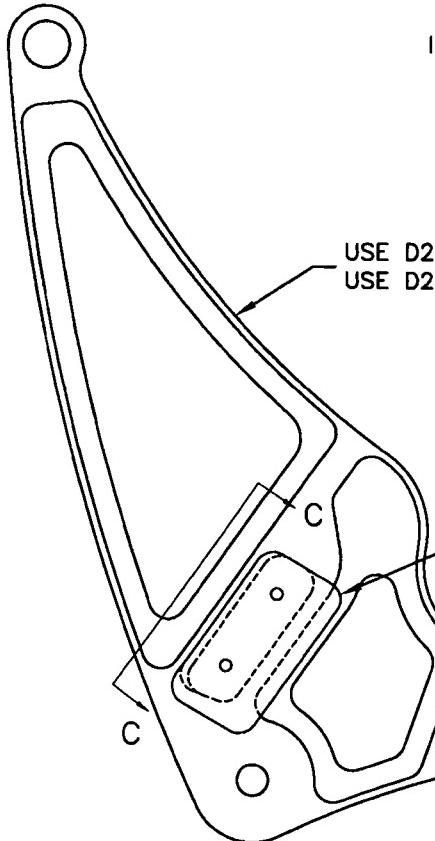
- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDprt"
 - 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500
 - 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
 - 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER
NO. _____

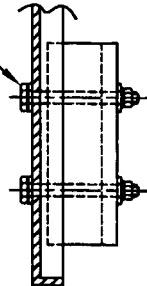
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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3



AN3C16A BOLT (1)
NAS1515H3 WASHER (2)
MS21042-3 NUT (1)
INSTALL BOLT WITH LPS-3 CORROSION
INHIBITOR (ENSURE NO LPS-3 ON THREADS)
(2 PLACES)



SECTION C-C
SCALE 1:3
(ROTATED)

USE D2805-1 FOR D2804-041
USE D2805-2 FOR D2804-042
USE D2805-3 FOR D2804-043
USE D2805-4 FOR D2804-044
PRESS INTO PLACE PRIOR TO POWDER COAT

PRESS D2809 INTO PLACE PRIOR TO
POWDER COAT

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**D2804-041/-043 BRACKET ASS'Y (SHOWN).
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)**

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANTEX (4.3.5.6)
OR BLACK SANTEX (4.3.5.7) OR GREEN SANTEX (4.3.5.8) PER DART QSI 005 4.3

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